

Date: Tuesday, 18/12/2007 1:44:00 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CUP
 Job Number : 36431
 Estimate Number : 13106
 P.O. Number : N/A
 This Issue : 18/12/2007 S.O. No. : NA
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Written By :
 Checked & Approved By :
 Comment : Est. A 07.12.18 new issue EC

Part Number : D30093
 Drawing Number : D3009 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : U/R
 Material : N/A
 Due Date : 20/12/2007 Qty: 40 Um: Each

OK 07/12/19

Additional Product



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R1000 Inventory



Comment: Qty.: 0.0503 f(s)/Unit Total : 0.6035 f(s)
 1018 7/8 ROUND BAR
 Material: AISI304/316 SS 1.00" Ø Round Bar
 (M304R1000)
 Batch: M 105 532

H.A 07/12/19

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA130 & DWG D3009
 FOLIO REV: A
 DWG REV: B
 2-DEBURR AS REQUIRED

B.A Fmk

07/12/19

20 07/12/20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A / Fmk 07/12/19

(41)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F 07/12/20

(41)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 454

FC

07/12/20

(41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/12/2007 1:44:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 36431

Part Number: D30093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



41

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/15

Job Completion



POSITIVE RECALL

EFFECTIVE 07/12/18 AUTH

RELEASED 08/01/14 DATE

2007/12/20

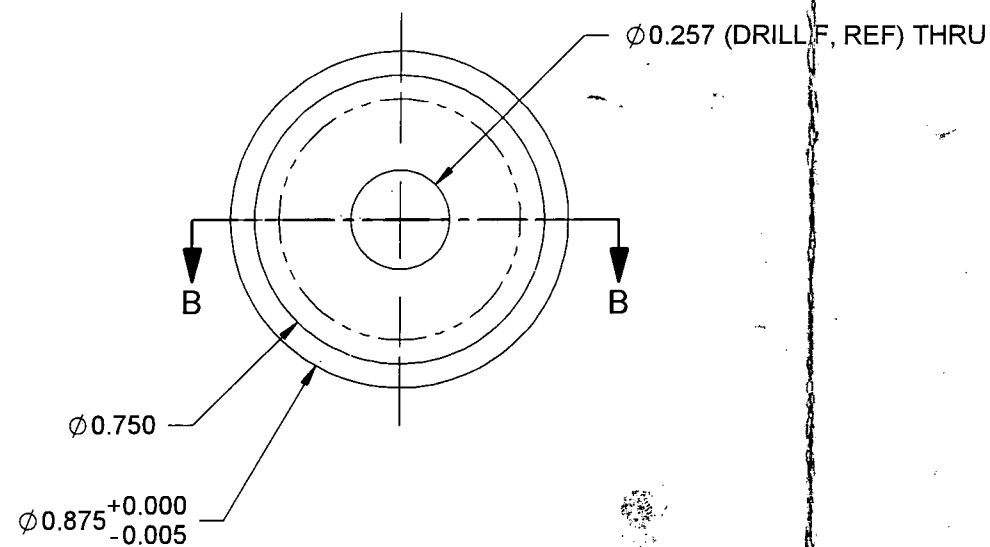
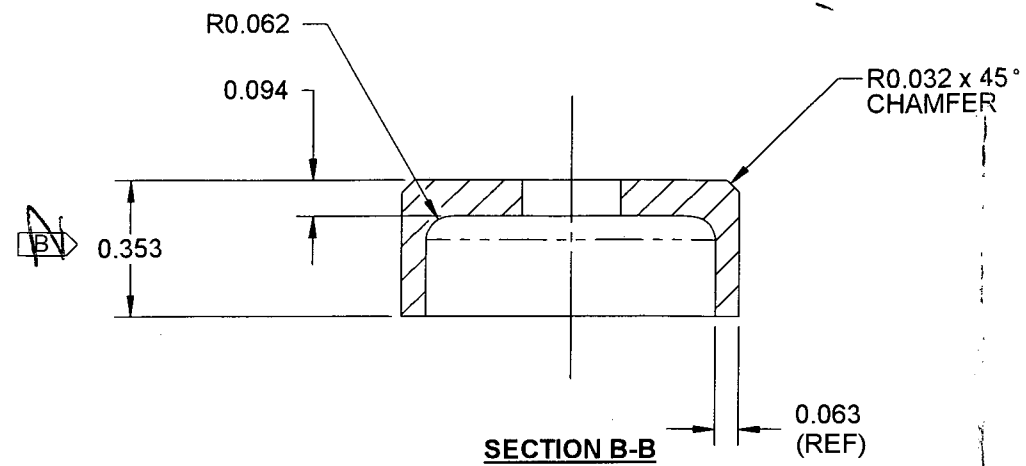
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3009-3 CUP

PRELIMINARY ISSUE

CP 07.12.17

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART SPEC M304R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3009	REV. B
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUP	2:1
DATE	07.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

L Lacelle

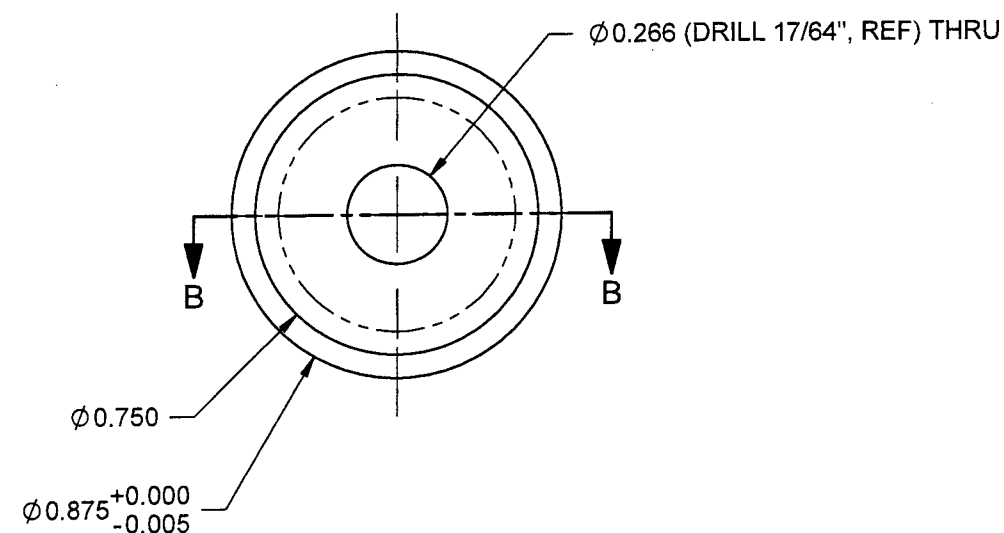
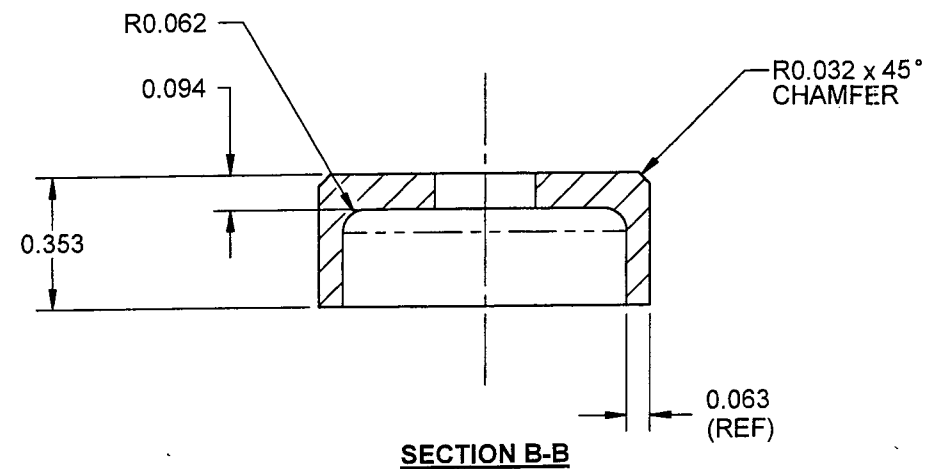
From: Chris Provencal [cprovencal@dartaero.com]
Sent: January 14, 2008 10:08 AM
To: 'L Lacelle'
Subject: RE: d3009-3

You can make them, if that's what you're asking. The D135-692-041 kit is under review (not approved yet), but the parts are OK to make.

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 14, 2008 9:46 AM
To: Provencal, Chris
Subject: d3009-3

Are they good now?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd



D3009-3 CUP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36431

RELEASE
08-01-07 JLD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART SPEC M304R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	921	DART AEROSPACE LTD	
DRAWN	921	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. B
MFG. APPR.		D3009	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUP	2:1
DATE	07.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	